

ship Dec 2.

Work Order ID 153163 - 2

153163

Page 1

Item ID: D5380-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Support

Start Date: 12/1/2016

Start Qty: 16.00

16

Cust Item ID:

Required Date: 12/1/2016

Req'd Qty: 16.00

16

Customer:

Reference:

Approvals:

Process Plan: Em

Date: 16/11/8

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D5380

B

100

0.02

100

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

8.44

HAAS CNC vertical machine #1

Machine as per Folio FB458

Folio Rev: AA

Dwg Rev: B

DAS

33

9-89

16/11/22

DAS

08

9-89

Deburr

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.03

Quality Control

DAS

33

9-89

16/11/22

DAS

08

9-89

P.T.O.

DQA:

Date:

2017-04-05



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

MAR 10 2017

Work Order update only ☐

Work Order: 153163-② split. Part No. D5380-1 NCR No. 17-6339		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Water Jet ☐ Engineering ☐ Machining ☒ Small Fab ☐ Prod. Eng. Coord. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐			
Date: 16-11-19		Step #: 100		QTY Effective: 12		MRB (QSI042) Approval DAS 9 9-89 16-11-23	
Description Work Order Deviation				Disposition			
1 on .625" hole is .015" instead of .005" (max) over the entire length of the hole axis in relation of the 2 surfaces within the (3.550") dimension. OK				→ reworked the 2 parts, so the top profiled surfaces, (R.650") are now at 0.000" instead of .015" on both parts but it affected 2 dimensions: 2.745" and .538" Part 1: (2.462 to 2.476) (.523) B.A. 16/11/21 Part 2: (2.460 to 2.476) (.524) after rework dimension .538" was found to be .005" under tolerance, therefore parts are not acceptable. Scrap qty 2 no replace.			
Root Cause Environment ☐ No Re-verification ☐ Design ☐ Operator ☐ Doc/Data ☒ Offset/Setup ☐ Equip/Tooling ☐ Supplier ☐ Handling/Pre ☐ Training ☐ Material ☐ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐				FAULT CATEGORY Pressure/Forced ☐ Temperature/Cure ☐ Power Loss/Surge ☐ Positioned Wrong ☐ Bending ☐ Set-up ☐ Folio/Program ☐ Outside Dimensions ☐ Centre Not Concentric ☐ BOM/Route ☐ Grain ☐ Over/Under tolerance ☐ Cracks ☐ Broken/Damage/Defect ☐ Weld ☐ Part Incorrect ☐ Crimp/Kink/Ripple/Wave ☐ Inspection Incomplete/Unqualified ☐ Wrong Stock Pulled ☐ Part Lost/Missing ☐ Cuffs ☐ Contamination ☐ Out of Sequence ☒ Part Moved ☐ Crushing ☐ Countersink ☐ Off-set ☐ Drawing ☐ Heat Treat ☐ Cut Too Short ☐ Misabeled ☐ Finish ☐ Wave/Twist in Tube ☐ Instructions Incomplete/Unclear ☐ Fit/Function ☐ Misread ☐ Marks/Chatter ☐ Drill Holes ☐ Mismatched/off center ☐ Turning Sequence ☐			
OTHER :							

Work Order ID 153163

Tuesday, November 08, 2016 1:16:38 PM

153163

Page 2

Item ID: D5380-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Support
Start Date: 12/1/2016 Start Qty: 16.00 ***16*** Cust Item ID:
Required Date: 12/1/2016 Req'd Qty: 16.00 ***16*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.05				14	0		DAS 14 9-89 11/6/128
121 *121* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.05				14			DAS 38 9-89 NOV 29 2016
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo LOCATION : LG054	0.00 0.03				14		NOV 29 2016	DAS 6 9-89

Work Order ID 153163

Tuesday, November 08, 2016 1:16:38 PM

153163

Page 3

Item ID: D5380-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Support
Start Date: 12/1/2016 Start Qty: 16.00 ***16*** Cust Item ID:
Required Date: 12/1/2016 Req'd Qty: 16.00 ***16*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC21 - Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.27							
Quality Control									

DAS
21
9-80

NOV 29 2016

Picklist Print

Tuesday, November 08, 2016 1:16:38 PM

Page 1

Work Order ID: 153163

153163

Parent Item: D5380-1

D5380-1

Parent Item Name: Support

Start Date: 12/1/2016

Required Date: 12/1/2016

Start Qty: 16.00

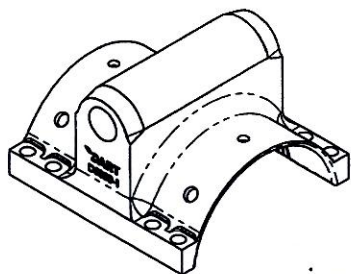
Required Qty: 16.00

Comments: IPP REV.A NEW ISSUE JFS 16/02/02 VERIFIED BY: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D5380-1TRN		Manufactured	No			100	Each	0.0000	0.5	8		DAS 33 9-89	
D5380-1TRN										**			
Support Turning Detail												16/11/18	

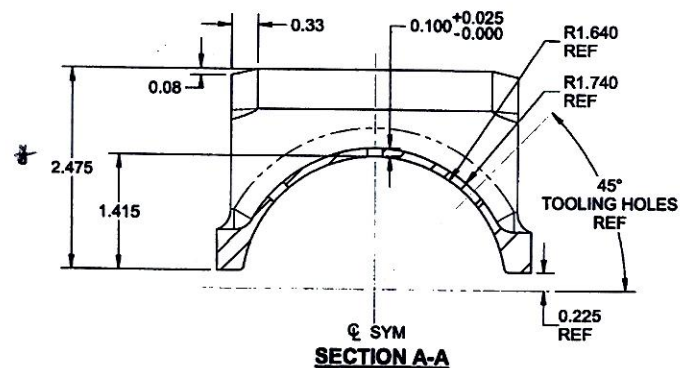
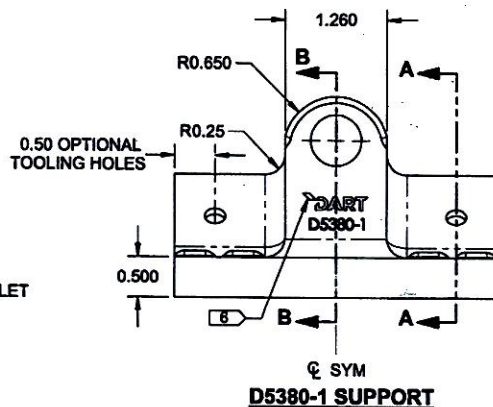
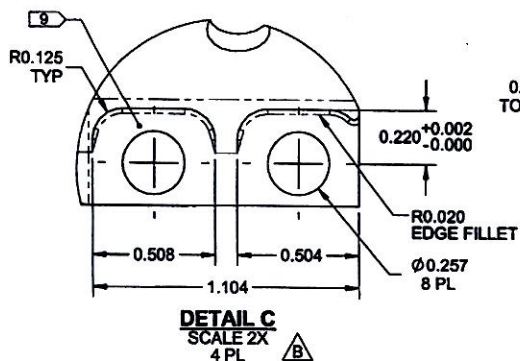
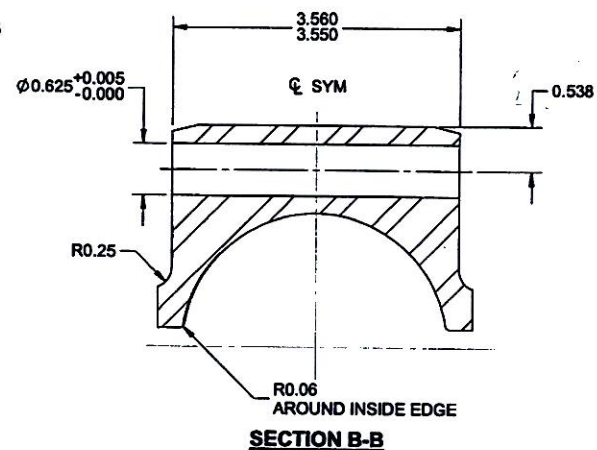
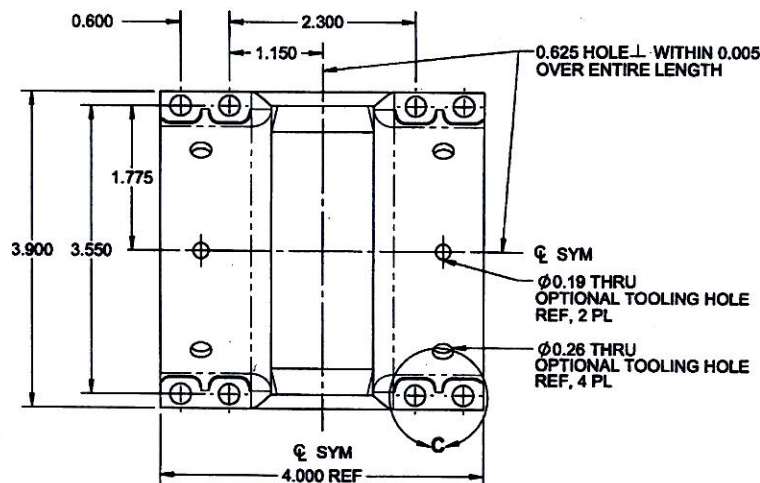
M 153165

8



SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 153163

2m 16/11/8



RELEASED

2016 NOV 08
2m 16-643

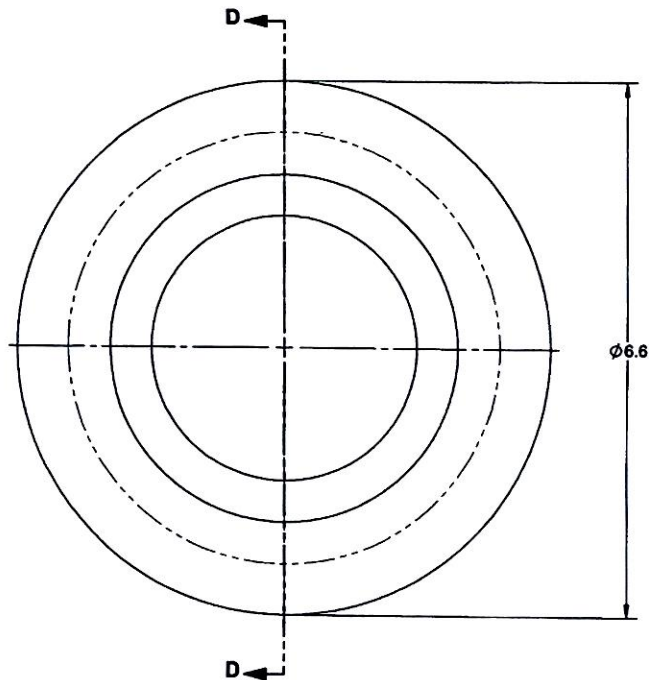
- NOTES:
1) MATERIAL: MAKE FROM D5380-1TRN
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: DART LOGO AND P/N WITH 0.125 HIGH LETTERING AND 0.005-0.010 DEEP PER DART QSI 044 6.3
7) WEIGHT: 2.08 lbs
8) PROFILE ALL NON DIMENSIONED FEATURES PER CAD FILE "D5380-1-REVB.STP"
9) REMOVE MATERIAL FLUSH TO FACE

B	MODIFY -1 PROFILE IN DETAIL C, INCREASE HOLE DIAMETER TO 0.257, MODIFY -3 TO ADD CORNER RAD TO CBORE AND INCREASE CBORE DIAMETER; UPDATE NOTES	ML	16.07.07
A	NEW ISSUE	ML	16.01.05
REV.	DESCRIPTION	BY	DATE
DESIGN	ML		
DRAWN	ML		
CHECKED	AJS		
MFG. APPR.	JFS		
APPROVED	WM		
DE APPR.	DS		
DATE	16.07.07		

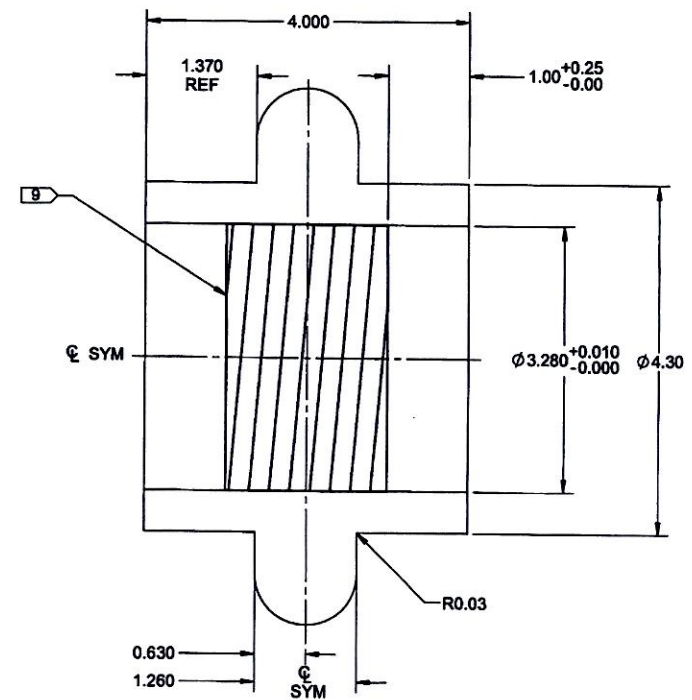
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D5380** REV. B
SHEET 1 OF 4
TITLE **SUPPORT** SCALE NTS

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D5380-1TRN



SECTION D-D

RELEASED

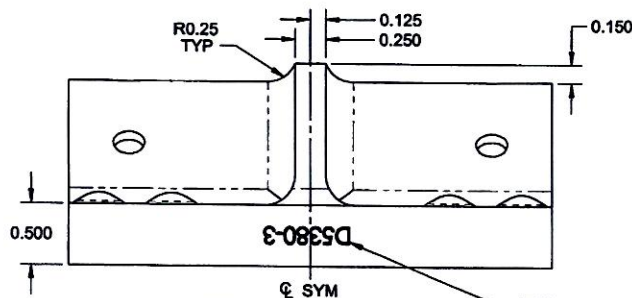
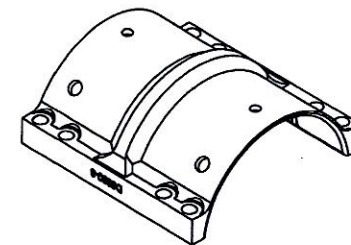
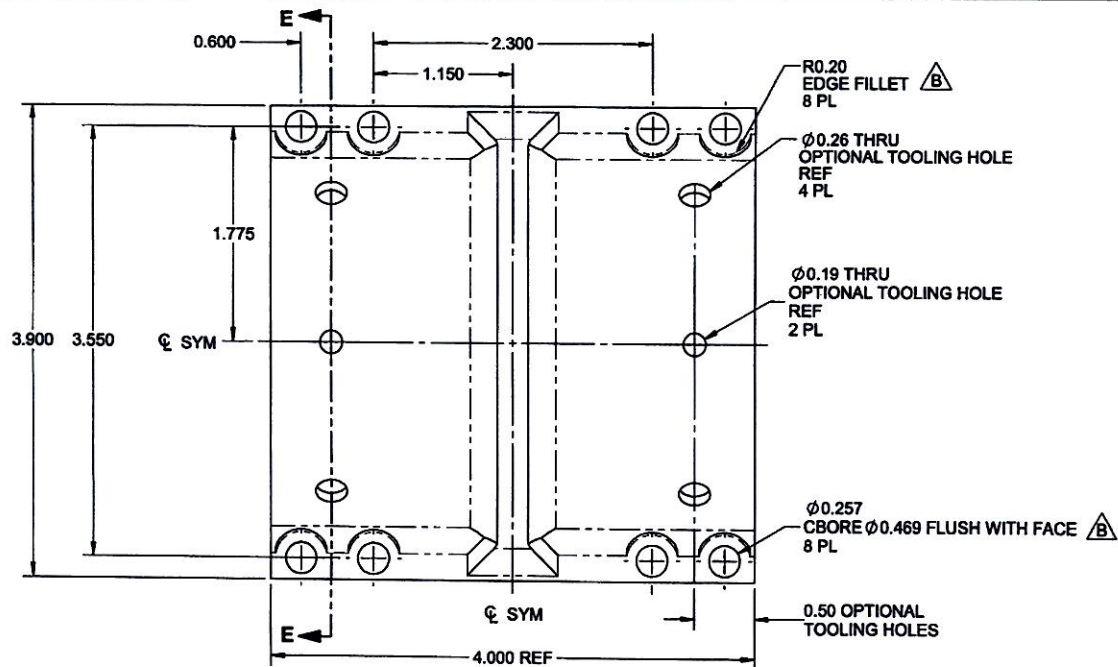
2016 NOV 08

NOTES:

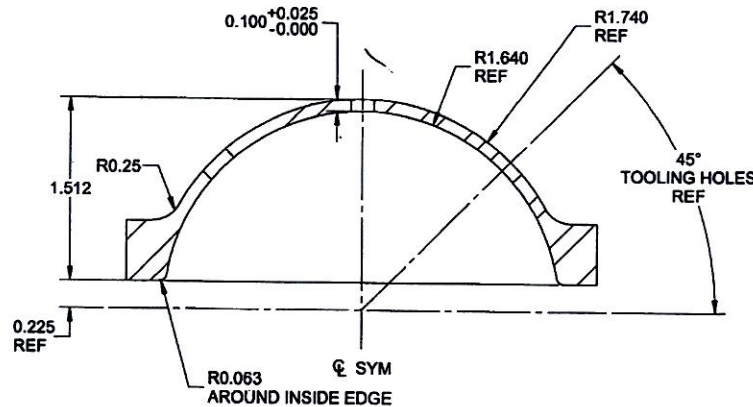
- 1) MATERIAL: 17-4 PH/S17400/TYPE 630 ROUND BAR PER AMS 5643 / ASTM A564 H900 OR H925 CONDITION, MIN UTS = 170 KSI (38 HRC) REF DART SPEC. M17-4-R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044
- 7) WEIGHT: 13.21 lbs
- 8) PROFILE ALL NON DIMENSIONED FEATURES PER CAD FILE "D5380-1TRN-REV8.STP"
- 9) SURFACE IS TO BE THREADED USING R0.032 TOOLING AT A DEPTH OF 0.032 (+0.005/-0.010) WITH A PITCH OF 0.125 (+0.010/-0.010)

APPROVED

DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED	AJS	DRAWING NO.	REV. B
MFG. APPR.	JFS	D5380	SHEET 2 OF 4
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	SUPPORT	NTS
DATE	16.07.07	COPYRIGHT © 2016 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D5380-3 SUPPORT BASE



SECTION E-E

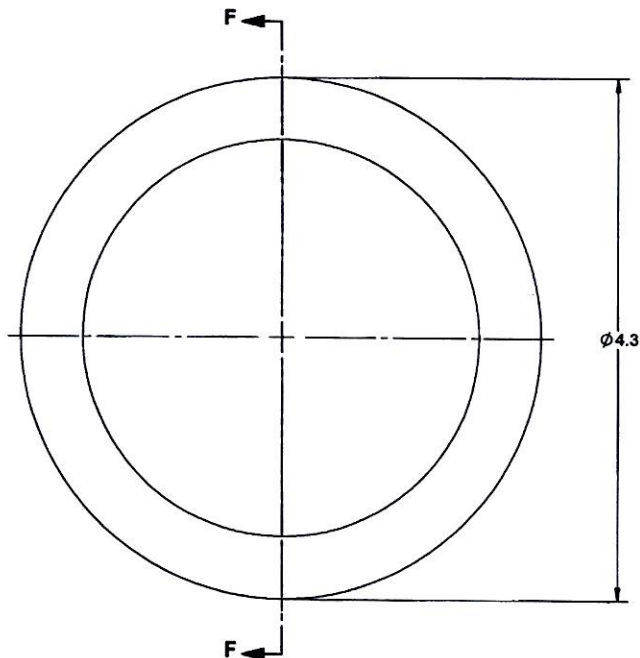
- NOTES:
- 1) MATERIAL: MAKE FROM D5380-3TRN
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: DART P/N WITH 0.125 HIGH LETTERING AND 0.005-0.010 DEEP PER DART QSI 044 6.3
 - 7) WEIGHT: 0.89 lbs
 - 8) PROFILE ALL NON DIMENSIONED FEATURES PER CAD FILE "D5380-3-REVB.STP"

RELEASED

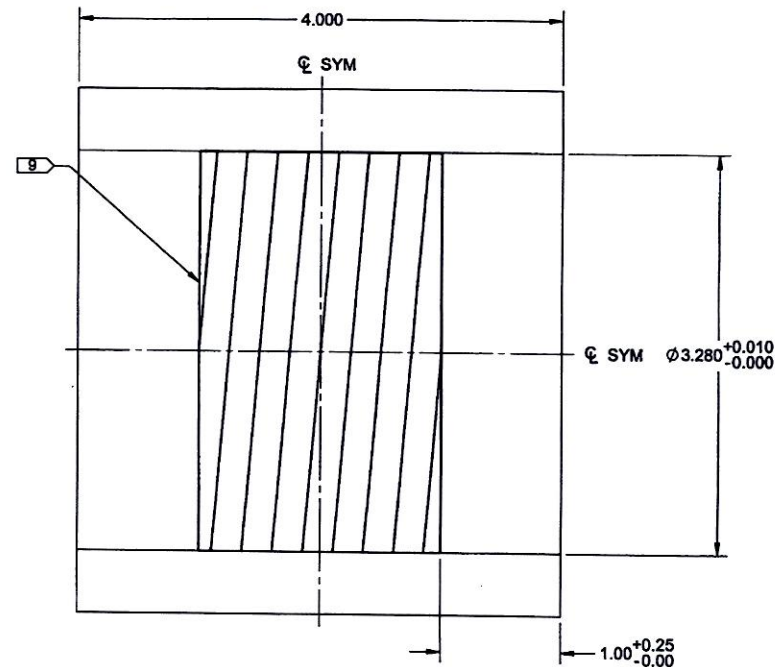
2016 NOV 08

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DESIGN	ML	DART AEROSPACE LTD	
DRAWN	ML	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO.	REV. B
MFG. APPR.	JFS	D5380	SHEET 3 OF 4
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	SUPPORT	NTS
DATE	16.07.07	COPYRIGHT © 2016 BY DART AEROSPACE LTD	
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D5380-3TRN



SECTION F-F

NOTES:

1) MATERIAL: 17-4 PH/S17400/TYPE 630 ROUND BAR PER AMS 5643 / ASTM A564
H900 OR H925 CONDITION, MIN UTS = 170 KSI (38 HRC)
REF DART SPEC. M17-4-R

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY PER DART QSI 044

7) WEIGHT: 7.02 lbs

8) PROFILE ALL NON DIMENSIONED FEATURES PER CAD FILE "D5380-3TRN-REVB.STP"

9) SURFACE IS TO BE THREADED USING R0.032 TOOLING AT A DEPTH OF 0.032 $\frac{+0.000}{-0.010}$ WITH A PITCH OF 0.125 $\frac{+0.010}{-0.010}$

RELEASED

2016 NOV 08

APPROVED

DESIGN	ML	DART AEROSPACE LTD	
DRAWN	ML	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO.	REV. B
MFG. APPR.	JFS	D5380	SHEET 4 OF 4
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	SUPPORT	NTS
DATE	16.07.07	COPYRIGHT © 2016 BY DART AEROSPACE LTD	
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DART AEROSPACE LTD		Work Order: 153163
Description: Ø Support D5380-1		Part Number: D5380-1
Inspection Dwg: D5380	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				SCRAP 1	SCRAP 2	3	4	5
HAAS Section								
AA	3.890	3.910		3.904	3.904	3.904	3.904	3.904
AB	0.256	0.263		0.257	0.257	0.257	0.257	0.257
AC	3.540	3.560		3.554	3.554	3.554	3.554	3.554
AD	1.765	1.785		1.777	1.777	1.777	1.777	1.777
AE	0.590	0.610		0.600	0.600	0.600	0.600	0.600
AF	1.140	1.160		1.150	1.150	1.150	1.150	1.150
AG	2.290	2.310		2.300	2.300	2.300	2.300	2.300
AH	3.550	3.560		3.557	3.557	3.557	3.557	3.557
AI	0.625	0.630		0.628	0.628	0.625	0.625	0.625
AJ	0.528	0.548	see NCR →	0.523	0.524	0.537	0.537	0.537
AK	0.498	0.518	1st page	0.505	0.505	0.505	0.505	0.505
AL	0.494	0.514		0.500	0.500	0.500	0.500	0.500
AM	1.094	1.114		1.099	1.099	1.099	1.099	1.099
AN	0.220	0.222		0.2215	0.222	0.2215	0.2215	0.2215
AO	0.490	0.510		0.499	0.500	0.500	0.500	0.500
AP	1.250	1.270		1.262	1.262	1.262	1.262	1.263
AQ	2.465	2.485	see NCR →	2.462	2.460	2.475	2.475	2.475
AR	1.405	1.425	1st page	1.417	1.419	1.418	1.418	1.418
AS	0.050	0.110		0.075	0.075	0.075	0.075	0.075
AT	0.300	0.360		0.320	0.320	0.320	0.320	0.320
AU	0.100	0.125		0.110	0.111	0.109	0.111	0.109
AV	0.220	0.280		0.250	0.250	0.250	0.250	0.250
AW	0.030	0.090		0.060	0.060	0.060	0.060	0.060
AX	0.010	0.030		0.015	0.015	0.015	0.015	0.015
AY	0.115	0.135		0.125	0.125	0.125	0.125	0.125
AZ	0.640	0.660		0.650	0.650	0.650	0.650	0.650
Ensure that Ø " bore is perpendicular to " bore within " Accept/Reject 0.0045" 0.001" 0.0045" 0.003" 0.001"								

Measured by: D. e	DAS 08	Date: 16-11-19
Audited by: 14	9-89	Date: 16/11/28
Preliminary Approval:		Date:

Rev	Date	Change	Revised by	Approved
A	08.04.24	New Issue	KJ/JLM	
B	12.07.31	Prototype revised to preliminary	KJ	

DART AEROSPACE LTD		Work Order: 153163
Description: Ø Support D5380-1		Part Number: 05380-1
Inspection Dwg: D5380	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				6	7	8	9	10
HAAS Section								
AA	3.890	3.910		3.904	3.904	3.904	3.904	3.904
AB	0.256	0.263		0.257	0.257	0.257	0.257	0.257
AC	3.540	3.560		3.554	3.554	3.554	3.554	3.554
AD	1.765	1.785		1.777	1.777	1.777	1.777	1.777
AE	0.590	0.610		0.600	0.600	0.600	0.600	0.600
AF	1.140	1.160		1.150	1.150	1.150	1.150	1.150
AG	2.290	2.310		2.300	2.300	2.300	2.300	2.300
AH	3.550	3.570		3.557	3.557	3.557	3.557	3.557
AI	0.625	0.630		0.625	0.625	0.625	0.625	0.625
AJ	0.528	0.548		0.537	0.537	0.537	0.537	0.537
AK	0.498	0.518		0.505	0.505	0.505	0.505	0.505
AL	0.494	0.514		0.500	0.500	0.500	0.500	0.500
AM	1.094	1.114		1.099	1.099	1.099	1.099	1.099
AN	0.220	0.222		0.2215	0.2215	0.2215	0.2215	0.2215
AO	0.490	0.510		0.500	0.500	0.500	0.500	0.500
AP	1.250	1.270		1.263	1.263	1.263	1.264	1.264
AQ	2.465	2.485		2.475	2.475	2.475	2.475	2.475
AR	1.405	1.425		1.418	1.418	1.422	1.420	1.420
AS	0.050	0.110		0.075	0.075	0.075	0.075	0.075
AT	0.300	0.360		0.320	0.320	0.320	0.320	0.320
AU	0.100	0.125		0.109	0.110	0.110	0.109	0.109
AV	0.220	0.280		0.250	0.250	0.250	0.250	0.250
AW	0.030	0.090		0.060	0.060	0.060	0.060	0.060
AX	0.010	0.030		0.015	0.015	0.015	0.015	0.015
AY	0.115	0.135		0.125	0.125	0.125	0.125	0.125
AZ	0.640	0.660		0.650	0.650	0.650	0.650	0.650
Ensure that Ø				" bore is perpendicular to " bore within "				
Accept/Reject				0.001"	0.001"	0.001"	0.0025"	0.0005"

Measured by: DAS 08	Date: 16-11-19
Audited by: 14 9-89	Date: 16/11/28
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	08.04.24	New Issue	KJ/JLM	
B	12.07.31	Prototype revised to preliminary	KJ	

DART AEROSPACE LTD		Work Order: 153163
Description: Ø Support D5380-1	Part Number: D5380-1	
Inspection Dwg: D5380	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	11	12	13	14	15
HAAS Section								
AA	3.890	3.910		3.904	3.904	3.904	3.904	3.901
AB	0.256	0.263		0.257	0.257	0.257	0.257	0.257
AC	3.540	3.560		3.554	3.554	3.554	3.554	3.551
AD	1.765	1.785		1.777	1.777	1.777	1.777	1.777
AE	0.590	0.610		0.600	0.600	0.600	0.600	0.600
AF	1.140	1.160		1.150	1.150	1.150	1.150	1.150
AG	2.290	2.310		2.300	2.300	2.300	2.300	2.300
AH	3.550	3.560		3.557	3.557	3.557	3.557	3.557
AI	0.625	0.630		0.625	0.625	0.625	0.625	0.625
AJ	0.528	0.548		0.537	0.537	0.537	0.537	0.537
AK	0.498	0.518		0.505	0.505	0.505	0.505	0.505
AL	0.494	0.514		0.500	0.500	0.500	0.500	0.498
AM	1.094	1.114		1.099	1.099	1.099	1.099	1.099
AN	0.220	0.222		0.2215	0.2215	0.2215	0.2215	0.2201
AO	0.490	0.510		0.500	0.500	0.500	0.500	0.500
AP	1.250	1.270		1.262	1.262	1.262	1.262	1.262
AQ	2.465	2.485		2.475	2.475	2.475	2.475	2.475
AR	1.405	1.425		1.418	1.418	1.417	1.418	1.417
AS	0.050	0.110		0.075	0.075	0.075	0.075	0.075
AT	0.300	0.360		0.320	0.320	0.320	0.320	0.320
AU	0.100	0.125		0.109	0.109	0.109	0.111	0.109
AV	0.220	0.280		0.250	0.250	0.250	0.250	0.250
AW	0.030	0.090		0.060	0.060	0.060	0.060	0.060
AX	0.010	0.030		0.015	0.015	0.015	0.015	0.015
AY	0.115	0.135		0.125	0.125	0.125	0.125	0.125
AZ	0.640	0.660		0.650	0.650	0.650	0.650	0.650
Ensure that Ø				" bore is perpendicular to	" bore within	"		
Accept/Reject				0.000"	0.0015"	0.003"	0.000"	0.0005

Measured by: B. DAS	Date: 16-11-20
Audited by: 14 DAS 9-89	Date: 16/11/28
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	08.04.24	New Issue	KJ/JLM	
B	12.07.31	Prototype revised to preliminary	KJ	

DART AEROSPACE LTD		Work Order: 153163
Description: Ø Support D5380-1	Part Number: D5380-1	
Inspection Dwg: D5380	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1G	2	3	4	5
HAAS Section								
AA	3,890	3,910		3,900				
AB	0,256	0,263		0,257				
AC	3,540	3,560		3,550				
AD	1,765	1,785		1,777				
AE	0,590	0,610		0,600				
AF	1,140	1,160		1,150				
AG	2,290	2,310		2,300				
AH	3,550	3,560		3,555				
AI	0,625	0,630		0,626				
AJ	0,528	0,548		0,538				
AK	0,498	0,518		0,505				
AL	0,494	0,514		0,504				
AM	1,094	1,114		1,104				
AN	0,220	0,222		0,2205				
AO	0,490	0,510		0,500				
AP	1,250	1,270		1,260				
AQ	2,465	2,485		2,475				
AR	1,405	1,425		1,418				
AS	0,050	0,110		0,080				
AT	0,300	0,360		0,300				
AU	0,100	0,125		0,108				
AV	0,220	0,280		0,250				
AW	0,030	0,090		0,060				
AX	0,010	0,030		0,015				
AY	0,115	0,135		0,125				
AZ	0,640	0,660		0,650				
Ensure that Ø " bore is perpendicular to " bore within "								
Accept/Reject				0,003				

Measured by: B.P.	DAS	DAS	Date: 16-11-21
Audited by: 14	DAS	33	Date: 16/11/28
Preliminary Approval:	9-89	9-89	Date:

Rev	Date	Change	Revised by	Approved
A	08.04.24	New Issue	KJ/JLM	
B	12.07.31	Prototype revised to preliminary	KJ	